

April 20

plus

Work Order ID 79753

79753

February-02-12 10:15:25 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Step, RH Crew
Start Date: 2/02/12 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 4/20/12 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4308	A								

100 0.00
100 Large Fab
Large Fab Memo 0.00
Large Fab 1-Cut D4308-1 using D2622 extrusion as per Dwg D4308
2-Drill, c'sink one hole on top of step as per dwg
3-Deburr and bevel ends for welding

Ae 12.04.3

110 0.00
110 QC6- Inspect dimensions to drawing
QC Memo 0.00
Quality Control

8.7/10/13

(74)

120 0.00
120 Weld per dwg A/R Aluminum rod Batch: 119785
Large Fab 120169 0.00
Memo 0.00
Large Fab 1-Weld end cap (ONE END ONLY)
2-Grind end cap welds flush
3-weld lugs as per Dwg D4308

12.04.03 4
Ae 12.04.04

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00				4	0		BE 12/6/04
130									
QC	Memo	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

8/7/04

(X4)
-642

4 BE 12/4/5.

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							De M. 12/04/12
170 *170* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 119185 Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remainig end cap as per Dwg D4308 3-Grind end cap weld flush as per dwg D2841 4- install rivert as per dwg	0.00 0.00							12.04.10 12.04.10
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							8/2/12/12

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 Start Date: 2/02/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/20/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				x4 RH			
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				H		12-4-11	
205 *205* SprayPaint Spray Painting	 Memo PRIME B 117319 DELFLEET BLUE B 121149 CLEAR DELFLEET B 118093	0.00 0.00				18		12-4-17 (4)	

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 Required Date: 4/20/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
206	QC14- Inspect Spray Paint	0.00				(4)			12.04.20
206									
QC	Memo	0.00							
Quality Control									
215	Wing Walk as per dwg QSI005 4.4 Batch 120902	0.00							
215									
HandFinish	Memo	0.00							
Hand Finishing									
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									

H. φ 12.04.20.
 4RH q ul nloka

Work Order ID 79753***79753***

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February-02-12 10:15:25 AM

Item ID: D4308-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 2/02/12 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/12 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: <u>420</u>	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

12/4/23

1204-23

Picklist Print

February-02-12, 10:15:24 AM

Page 1

Work Order ID: 79753

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 2/02/12

Required Date: 4/20/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.01.07 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C
Step Extrusion

Manufactured No

100 Each 166.7700

0.05

0.2

Ac 12.03.28

Location	Loc Qty	Loc Code
----------	---------	----------

HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA013	150.4	
75781	20.4	
77612	130	

D2734
Step End Plate

Manufactured No

120 Each 107.0000

1

4

12.04.03

Location	Loc Qty	Loc Code
----------	---------	----------

WA	107	
76985	107	
<u>B80682</u>	170	

D2734
Step End Plate

Manufactured No

170 Each 107.0000

1

4

12.04.03

Location	Loc Qty	Loc Code
----------	---------	----------

WA	107	
<u>B80682</u>	107	
76985	107	

D3458-1
Step Mounting Plate

Manufactured No

120 Each 11.0000

1

4

12.04.03

Location	Loc Qty	Loc Code
----------	---------	----------

WA002	10	
75609	10	
WA018	1	
63075	1	

Picklist Print

February-02-12 10:15:24 AM

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Work Order ID: 79753

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 2/02/12

Required Date: 4/20/12

Start Qty: 4.00

Required Qty: 4.00

D3458-3

Manufactured No

120

Each

21.0000

1

4

12.04.03

Step Mounting Plate

Location

Loc Qty

Loc Code

WA002

21

75610

21

4

MS20601-AD4W2

Purchased

No

170

Each

103.0000

1

4

12.04.10

Rivet

Location

Loc Qty

Loc Code

ST322

12/255

103

119232

103

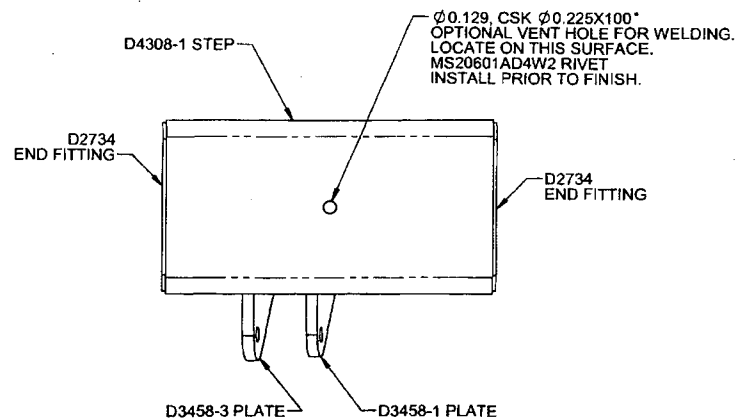
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February-02-12 10:15:24 AM

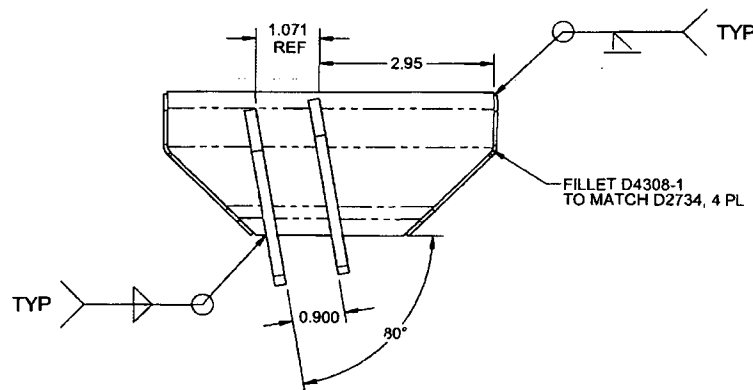
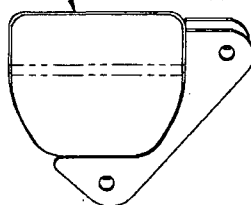
Shop Packet Print

Page 2

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

NO. 79853-4.5
12/02/01

RELEASED
2011-05-26

REV.	DESCRIPTION	CP	10.12.17
A	NEW ISSUE	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4308**
REV. A
SHEET 1 OF 3
TITLE **STEP, CREW**
SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

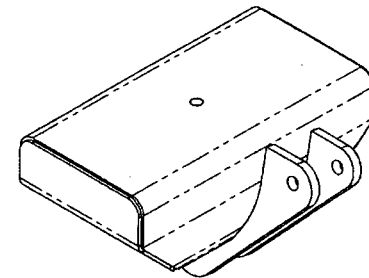
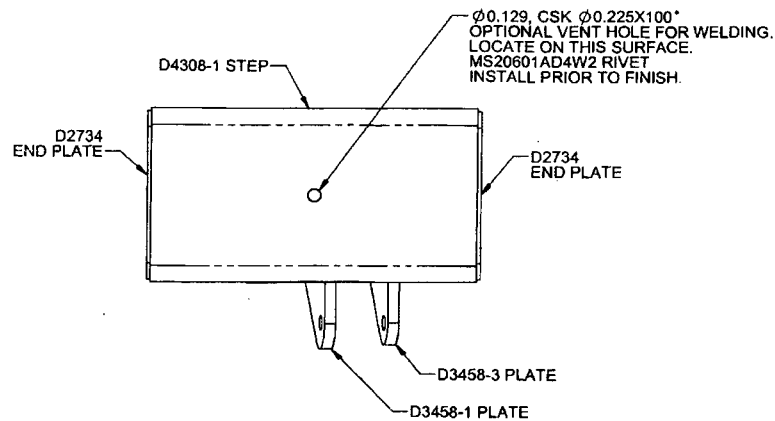
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

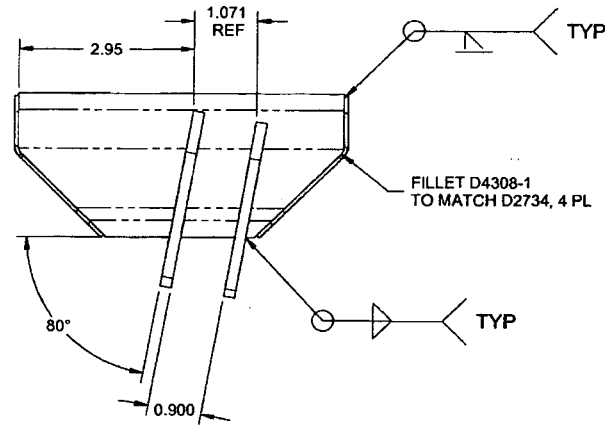
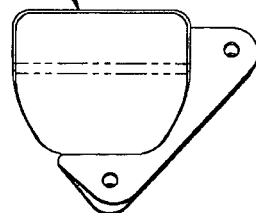
NOTE: Date & initial all entries

79642

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-042 STEP, RH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2011-05-31
AM

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4308	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		STEP, CREW	SCALE
DE APPR.			NTS
DATE	10.12.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

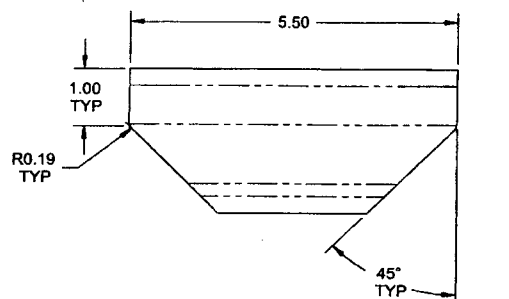
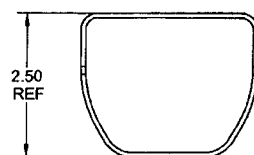
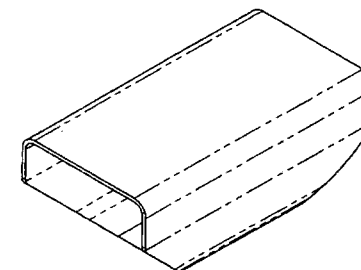
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79642

**D4308-1 STEP****NOTES:**

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	MD	D4308	SHEET 3 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	STEP, CREW	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries